

174 H900 010

Work Order ID 127751

127751

December-17-14 1:52:59 PM

Page 1

Item ID: D3691-1

Accept

N900040100

Setup Start *NS1*

Revision ID:

Item Name: Stud

Stop *NS2*

Start Date: 12/17/14 Start Qty: 4.00

4

Cust Item ID:

Required Date: 12/17/14 Req'd Qty: 4.00

4

Customer:

Reference:

Approvals: Process Plan: MLJ Date: 14-12-19

Tooling:

Date:

Run Start *NR1*

QC: Date: SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D3691

E

100

100

BAND SAW

0.00

Bandsaw

Memo

0.00

Jeaspa Bandsaw

DO NOT USE CHOP SAW

Cut blank 7.750" long

DAS
40
9-89

4

Ø

15/01/15

110

110

DOOSAN LATHE

0.00

Doosan

Memo

0.00

Doosan Lathe

1-Turn as per Folio FA716 Rev: AD & Dwg D3691 Rev: E 2-Deburr
per dwg D3691
3-Check .625" bore with DT9530 GO/NO GO Gauge

DAS
40
9-89

15/01/16

160

160

QC2- Inspect parts off machine FAI/FAIB

0.00

QC

Memo

0.00

Quality Control

DAS
40
9-89

15/01/16

PTO

DQA:

Date: 15/04/08



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: PRN

Date: 15/04/06

Work Order update only ☐

Work Order: <u>127751</u>	DISPOSITION Rework ☐ Scrap ☒ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS			
Part No. <u>D3691-1</u>		Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐
NCR No. <u>15-4796</u>		Machining ☒	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐
		Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐
		Large Fab ☐	Composite ☐	Supplier ☐	

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector	
Design	15/01/16	110	1	Thread insert Broke	J 15/01/29 Q2012.	Scrap no Replace	DAS 40 9-09	PD 15-01-16		
Doc/Data				Making the Thread		BATCH M127334	15/01/16			
Equip/Tooling				Rnt unusable.						
Handling/Pre										
Material										
Operator										
Offset/Setup										
Process				R.C. Process Tooling.		\$ 223.95	15/01/20			
Supplier						some 9's w/o summary	DAS 08 9-89			
Training										
Transport										
Unapproved										

FAULT CATEGORY

Landing Gear	General		
☐ Bending	☐ Bend	☐ Folio/Program	☐ Outside Dimensions
☐ Centre Not Concentric	☐ BOM/Route	☐ Grain	☐ Over/Under tolerance
☐ Cracks	☐ Broken/Damage/Defect	☐ Hardware	☐ Part Incorrect
☐ Crimp/Kink/Ripple/Wave	☐ Burrs	☐ Inspection Incomplete/Unqualified	☐ Part Lost/Missing
☐ Cuffs	☐ Contamination	☐ Instructions Incomplete/Unclear	☐ Part Moved
☐ Crushing	☐ Countersink	☐ Misaligned/off center	☐ Positioned Wrong
☐ Heat Treat	☐ Cut Too Short	☐ Mislabeled	☐ Power Loss/Surge
☐ Inspection Strip in Tube	☐ Drawing	☐ Misread	☒ Other
☐ Marks/Chatter	☐ Drill Holes	☐ Off-set	<u>Tool Failure</u>
☐ Turning Sequence	☐ Finish	☐ Out of Calibration	
☐ Wave/Twist in Tube	☐ Fit/Function	☐ Out of Sequence	

Work Order ID 127751

127751

December-17-14 1:52:59 PM

Page 2

Item ID: D3691-1 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Stud
 Start Date: 12/17/14 Start Qty: 4.00 ***4*** Cust Item ID:
 Required Date: 12/17/14 Req'd Qty: 4.00 ***4*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

170	QC8- Inspect parts - second check	0.00				4	0		DAS 08 9-89
-----	-----------------------------------	------	--	--	--	---	---	--	-------------------

170

QC

Quality Control

Memo

100% CHECK,CHECK ALL DIMENSIONS AND THREAD FIT

0.00

0.00

171

171

Purchasing

Purchasing

Memo

Liquid Penetrant Inspection as per QSI 038

Issue P/O: 27400

LPI as per dwg D3691

Attach copy of NDT results to work order

0.00

173

173

Packaging

Packaging

Receive & Inspect for Damage & Mat'l Certs

0.00

Memo

0.00

CG 15/02/17 (Y)

4X SP15-02-17

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width:100%;"> <tr> <td>Skid-tube ☐</td> <td>Crosstube ☐</td> <td>Water Jet ☐</td> <td>Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>	Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐															
Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐															
Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐															
Large Fab ☐	Composite ☐	Supplier ☐																

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
--	--	---	--

Work Order ID 127751***127751***

Page 3

Item ID: D3691-1

Accept

N900040100Setup Start ***NS1***

Revision ID:

Item Name: Stud

Stop ***NS2***

Start Date: 12/17/14 Start Qty: 4.00

4

Cust Item ID:

Required Date: 12/17/14 Req'd Qty: 4.00

4

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start ***NR1***
Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
175	QC5- Inspect part completeness to step on W/O	0.00							
175									
QC	Memo	0.00							
Quality Control									
180	Identify as per dwg & Stock Location: 5231B	0.00							
180									
Packaging	Memo	0.00							
Packaging									
190	QC21- Final Inspection - Work Order Release	0.00							
190									
QC	Memo	0.00							
Quality Control									

FEB 17 2015

DAS
06
9-89

4 FEB 18 2015

15/2/18

MS 2-18

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width: 100%;"> <tr> <td>Skid-tube ☐</td> <td>Crosstube ☐</td> <td>Water Jet ☐</td> <td>Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>	Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐															
Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐															
Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐															
Large Fab ☐	Composite ☐	Supplier ☐																

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
--	--	---	--

Picklist Print

December-17-14 1:52:59 PM

Page 1

Work Order ID: 127751

127751

Parent Item: D3691-1

D3691-1

Parent Item Name: Stud

Start Date: 12/17/14

Required Date: 12/17/14

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP Rev:A New Issue 08-01-29 JLM Verified By:EC
IPP Rev:B Material Change 09-01-07 JLM Verified By:EC IPP
REV:C AS PER REV D 10-03-16 JLM VERIFIED BY:EC
IPP Rev:C Added note on Step 2 09-01-26 JLM Verified By:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M174PH-H900R1.000		Purchased	No				f	57.8330		3			
M174PH-H900R1 000									**			15/01/15	DAS 40 9-89
17-4SS H900 ROUND BAR 1.00													

Location

Loc Qty

Loc Code

MAT031

57.833

→ m120767

3

m126952

9

m128314

45.833

3.0

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width: 100%;"> <tr> <td>Skid-tube ☐</td> <td>Crosstube ☐</td> <td>Water Jet ☐</td> <td>Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>	Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐															
Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐															
Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐															
Large Fab ☐	Composite ☐	Supplier ☐																

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence
		☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge
		☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other

DART AEROSPACE LTD		Work Order:	127751
Description: Stud		Part Number:	D3691-1
Inspection Dwg: D3691 Rev: E		Page 1 of 1	

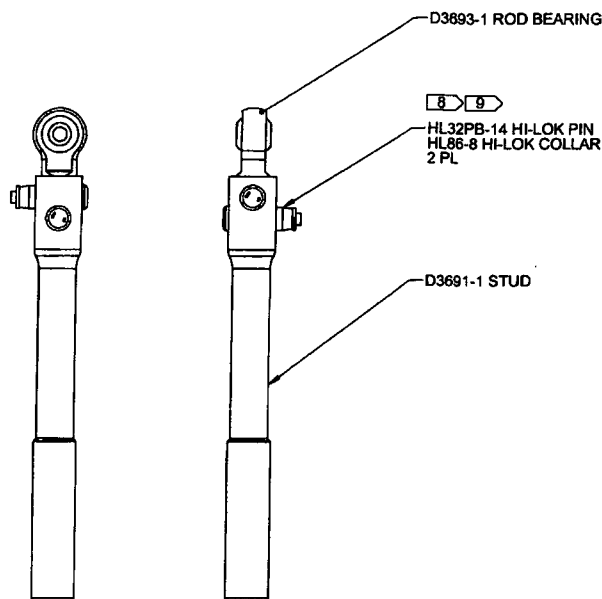
FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.695	+/-0.010	.695	✓		VGW	PHD-12
45°	0.5°	45°	✓		Ang G	
0.623	+0.004/-0.000	.623	✓		PIN G	
1.25	+0.000/-0.03	1.231	✓		VGW	PHD-12
118°	0.5°	118°	✓		Ang g	
R0.03	+/-0.030	.03	✓		Rad g	
0.11 Ref	+/-0.030	.11	✓		VGW	PHD-12
90°	0.5°	90°	✓		Ang g.	
Ø0.216	+0.005/-0.001	.217	✓		VGW	PHD-12
1.31	+/-0.030	1.335	✓		"	"
1.65	+/-0.030	1.65	✓		"	"
0.750	+0.000/-0.010	.750	✓		"	"
Ø0.659	+0.000/-0.015	.651	✓		"	"
7.625	+/-0.015	7.625	✓		"	CWC-02
2.90	+/-0.030	2.900	✓		"	PHD-12
3/4-16UNF-2A	N/A		✓			
0.075 x 45°	+/-0.010 x 0.5°	.075	✓		"	"
0.375	+0.000/-0.010	.374	✓		"	"
Ø0.216	+0.005/-0.001	.217	✓		"	"
R0.25	+/-0.030	.25	✓		Rad G	
R0.50	+/-0.030	.50	✓		"	
Ø0.825	+/-0.010	.826	✓		VGW	PHD-12

DAS		DAS		DAS	
Measured by:	40 9-89	Audited by:	M.A. 08 9-89	Preliminary Approval:	
Date:	15/01/16	Date:	15/01/20	Date:	

Rev	Date	Change	Revised by	Approved
A	09.05.11	New Issue	KJ	
B	09.11.04	Dwg Rev updated	KJ	
C	10.03.31	Dimensions revised per Dwg Rev D	KJ	
D	13.02.27	Ø0.216 was Ø0.189	KJ	
E	13.11.04	Dimensions revised	KJ	

ITEM	QTY	P/N	DESCRIPTION
1	X	D3691-041	STUD ASSEMBLY
2	1	D3691-1	STUD
3	1	D3693-1	ROD END BEARING
4	2	HL32PB8-14	HI-LOK PIN
5	2	HL86-8	HI-LOK COLLAR



D3691-041 STUD ASSEMBLY

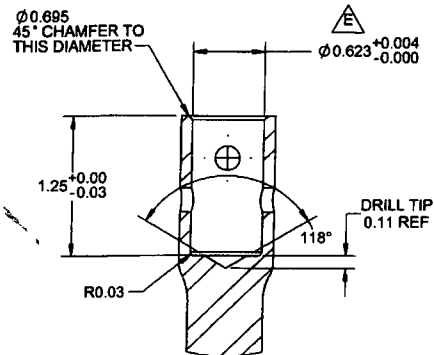
NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 1.04 lbs
- 8) ALIGN THE PILOT HOLES IN D3693-1 WITH PILOT HOLES IN D3691-1. ENLARGE EACH HOLE USING A P/N 13-420 PILOTTED DRILL (0.2314 DIA./0.2158 PILOT). REAM EACH HOLE USING A P/N 44-300 STEP REAMER (0.247 DIA./0.2314 PILOT). CLEAN AND DEBURR ALL HOLES PRIOR TO ASSEMBLY.
- 9) ASSEMBLE D3693-1 WITH D3691-1 USING HYSOL EA934NA OR MAGNOBOND 6398 ADHESIVE BETWEEN MATING SURFACES.

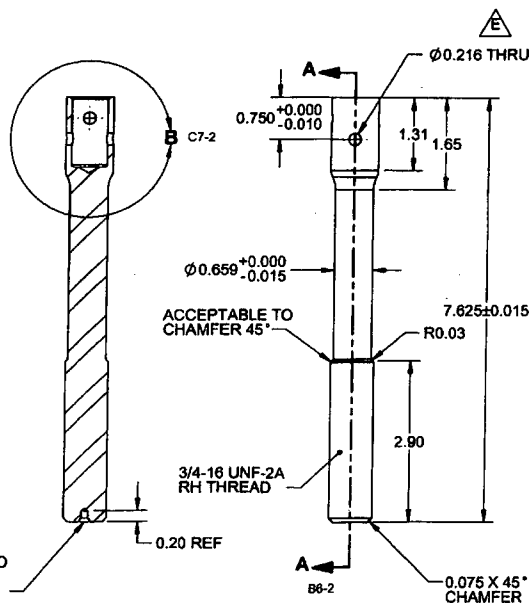
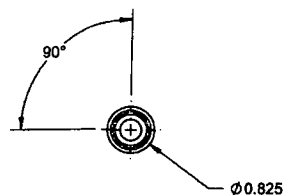
SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 127751 MJS
(4-12-19)

RELEASED
2013-01-22
MJS

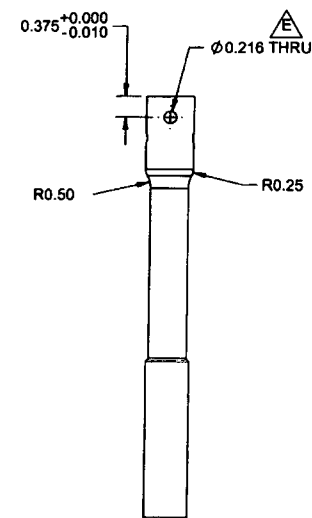
E	ADD -041 STUD ASSEMBLY, ASSEMBLY INSTRUCTIONS (ZN A8-1, ZN B6-1, ZN D7-1), Ø0.216 WAS Ø0.189 (ZN D2-2, D4-2), Ø0.823 WAS Ø0.825 (ZN D7-2), RE-FORMAT NOTES SECTION AS PER QSI 043 (ZN A8-1), REF NCR 12-2074		DB	12.12.07
D	7.625 WAS 7.750 (ZN C4-1)		RF	10.03.03
C	0.20 WAS 0.16 & CENTER DRILL #4 WAS CENTER DRILL #2 (ZN B6-1), UPDATE NOTE 8 TO REF QSI (ZN A8-1)		RF	09.09.09
B	CHANGE TO 17-4PH H-900 (ZN A8-1), Ø0.695 WAS Ø0.665 (ZN D8-1) REFORMATTED TO CURRENT DWG STANDARDS		RF	08.11.24
A	NEW ISSUE		RF	08.03.12
REV.	DESCRIPTION		BY	DATE
DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		
DRAWN	DB			
CHECKED	MB	DRAWING NO.	REV. E	
MFG. APPR.	JLM	D3691	SHEET 1 OF 2	
APPROVED	MJS	TITLE	SCALE	
DE APPR.		STUD	NTS	
DATE	12.12.07	COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL. IT IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.		



DETAIL B CS-2
SCALE 1:1



SECTION A-A B4-2



NOTES:

- 1) MATERIAL: 17-4PH STAINLESS STEEL ROUND BAR PER AMS 5843 H-900 CONDITION
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.80 lb
- 8) LPI PER QSI 038 4.1.1 (ASTM E1417 LEVEL 2)

DESIGN	RF	DART AEROSPACE LTD	
DRAWN	DB	HAWKESBURY, ONTARIO, CANADA	
CHECKED	MB	DRAWING NO.	REV. E
MFG. APPR.	JLM	D3691	SHEET 2 OF 2
APPROVED		TITLE	SCALE
DE APPR.		STUD	NTS
DATE	12.12.07	COPYRIGHT © 2008 BY DART AEROSPACE LTD	
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.			

RELEASED
2013-01-22

skyservice Work Order Traveler

Sky Service F.B.O. Inc.

DOT APP 53-89 / EASA 145.7142 / BDA AMO 385

WO #: MWO23619	Customer: Dart Aerospace Ltd.	Dept: NDT YUL	Reference: 27400
Descr:	PN:	S/N:	Qty: 1
Make:	Model:	Reg:	A/C S/N:
TSN:	CSN:	TSO:	

Task: UNSCHEDULED	Sequence: 1
-------------------	-------------

Work Required:

CARRY OUT NDT ON FOUR PARTS

ITEM ID : D3691-1 STUD - WO ID: 127751 - QTY: 4

Action Taken:				Date:	Initial/Stamp:	
LIQUID PENETRANT INSPECTION CARRIED OUT AS PER ASTM E-1417M-13				FEB 12 2015		
NO CRACK FOUND						
PEN.(ZL-37 , B#120M93), DEV.(SKD-S2,B#13M2K) , EMU.(ZR-10B,B#12J081).				SP 15-02-17		
Description	Location	P/N	Qty	Batch	S/N Off	S/N On
			DAS			
			38			
			9-88			
			FEB 17 2015			

I certified that the maintenance described above has been performed in accordance with the applicable standard of airworthiness.

Signature:	ACA/SCA Stamp	Date:
Name: RAFIK MELIKIAN		FEB 12 2015



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

OUTSTANDING PO REPRINT

Purchase Order ID PO27400

Purchase Order Date 2/11/2015

PO Print Date 2/17/2015

Page Number 1 of 1

Order From : VC-SKY001
SKYSERVICE
6120 MIDFIELD ROAD
MISSISSAUGA, ONTARIO L5P 1B1
CANADA

Ship To : DART AEROSPACE LTD
1270
ABERD
EEN
HAWKE
SBURY,
ON
K6A
1K7
CANAD
A

Contact Name		Buyer	Chantal Lavoie
Vendor Phone	905-678-5636	Customer POID	
Vendor Fax	905-678-5841	Customer Tax #	10127-2607
Ship To Contact		Terms	Net 30
Ship To Phone		Currency	CAD
		FOB	FCA - (Free Carrier)
Ship Method	Delivered		
Ship Acct			

Line Nbr	Item ID Vendor Part Number Line Comments Delivery Comments	Description/ Mfg ID	Req Date/ Taxable	Req Qty	Extended Price
16	127751	D3691-1 STUD	2/17/2015 Yes 2/17/2015	4.00 ✓	\$89.00
LIQUID PENETRANT INSPECTION AS PER QSI 038 OR LPI AS PER ASTM 1417 LEVEL 2					

SP15-02-17
Line Total: \$89.00

Outstanding PO Total: \$89.00

Change Nbr: 3

Change Date: 2/17/2015

CL
Terms & Condition of
Purchasing(Suppliers) and
Procurement Quality Clauses are an
integral part of our AS9100